

*Date: Tuesday, 13/05/2008 9:28:05 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LITTER TIE DOWN ASS'Y
Job Number : 39221	
Estimate Number : 10360	
P.O. Number :	Part Number : D2350
This Issue : 13/05/2008 S.O. No. :	Drawing Number : D2350 / D2363
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B / F
Previous Run : 36696	Material :
Written By :	Due Date : 18/06/2006 Qty: 6 Um: Each
Checked & Approved By : <u>JUL 08.5.13</u>	
Comment : est rev B 06.05.17 added ass'y EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6201	"T" Extrusion
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Comment: Qty.: 1.0631 f(s)/Unit Total: 6.3788 f(s)

Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion

Batch:

B36793

mk 08/05/20

①

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut blanks: 12.150" long

mk 08/05/20

②

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Machine as per Folio D2363 and Dwg D2363

mk 08/05/20

③

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

mk 08/05/20

④

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 08/05/21 46

6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Tumble & deburr

mk 08/05/21

⑤

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 2350 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/06/04
 QA: N/C Closed: _____ Date: _____

NCR: 39221		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/21	3	MAT'L UNDER SIZED. DIM 1.70" IS 1.65" DIM 4.00 (REF) IS 3.957	CP 08.05.21 per Q51642	PART OK. REF DS EMAIL	CP 08/05/21	CP 08/05/21 per Q51642	CP 08.05.21 per Q51642	CP 08/05/21

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASSY

Job Number: 39221

Part Number: D2350

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/22 (46)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-05-21

9.0

POWDER COATING

POWDER COATING



M 107925



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:00
320°F
10:00

m.p. 08/05/22

(6x)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 08-05-22

11.0

D2372

Quick Release



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2372 Fastener

(6x)
37448

B 3 9 4 5 2

(1)

sq

12.0

D2444

Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2444 Pip Pin

(4x)
38108

(2x)
38895

sq

13.0

AN960JD10L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

3 AN960JD10L Washer

109885

8/5/23

sq

(6x)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 13/05/2008 9:28:06 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 39221

Part Number: D2350

Job Number:



Seq. #:	Machine Or Operation:	Description :
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14.0	MS21042L3	Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 MS21042L3 Nut (or -3) 107644

SP

15.0	MS27039113	Screw
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(6X)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-1-13 Screw 13719

8/5/23

SP

16.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2350

08/06/23 (6)

17.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/06/23 (6)

18.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57/85

08/6/23 (6)

19.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/06/04

Job Completion



MF 08-06-04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

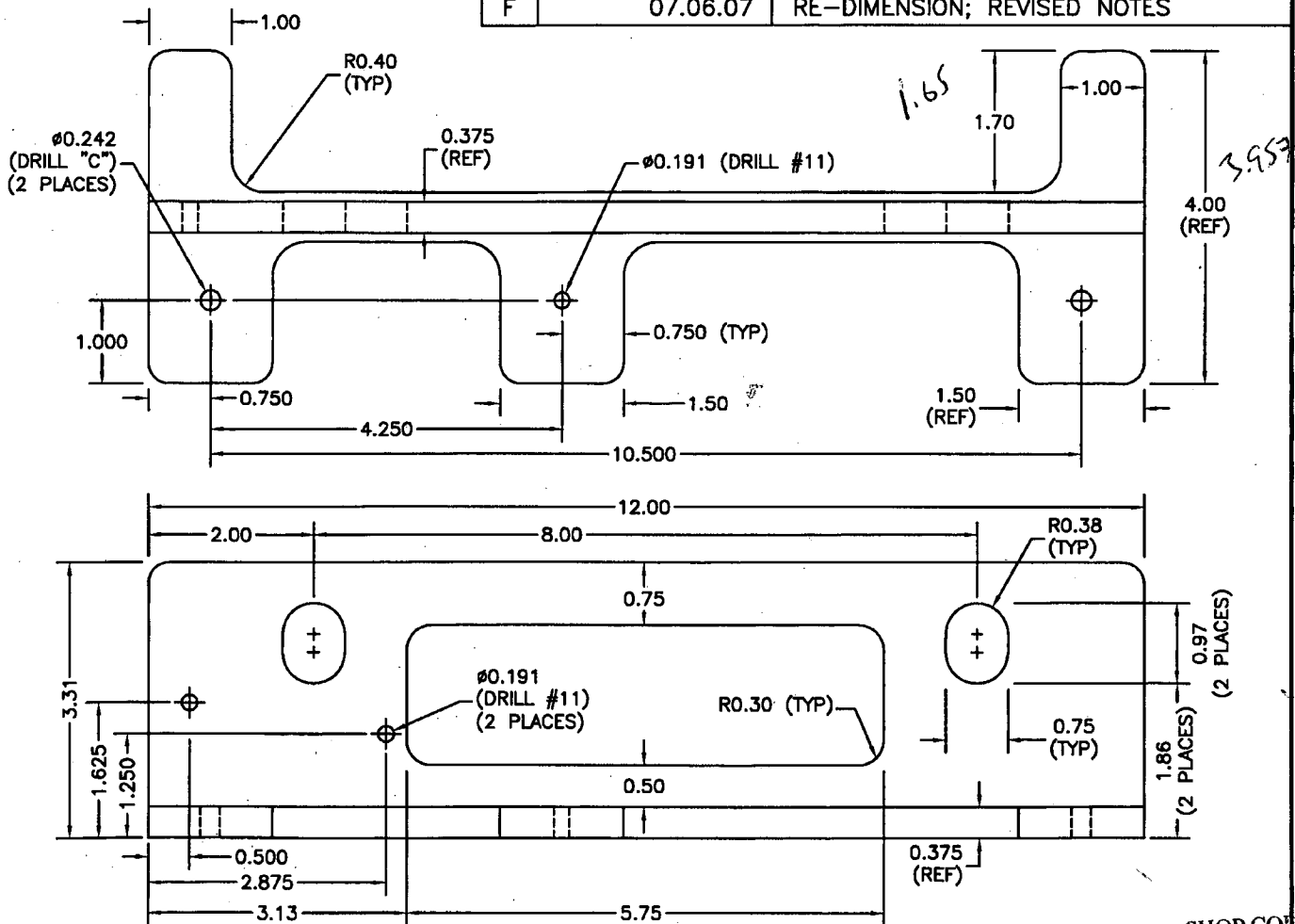
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AB</i>	APPROVED <i>HA</i>	DRAWING NO. D2363	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER TIE DOWN BRACKET	SCALE 1:2
A	95.01.14	NEW ISSUE	
B	95.02.14	MODIFIED HOLES	
C	95.03.06	0.191 WAS 0.197	
D	95.03.06	CHANGES TO DIMENSIONS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	RE-DIMENSION; REVISED NOTES	

**D2363 LITTER TIE DOWN BRACKET**

- 1) MATERIAL: MAKE FROM D6201-012 EXTRUSION (6061-T6/T651 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2363" USING FINE POINT PERMANENT INK MARKER

RELEASED07.06.22 *HA*

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NO. 37221

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B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED BW	APPROVED [Signature]	D2350	SHEET 1 OF 2
DATE 95:02:20	TITLE LITTER TIE DOWN ASSEMBLY		SCALE

RELEASED
960607

D2350	Part No.	Description
X	D2350	LITTER TIE DOWN ASSEMBLY (NON-LOCKING)
1	D2363	LITTER TIE DOWN (NON-LOCKING)
2	D2372	QUICK RELEASE FASTENER
1	D2444	PIP PIN
13	AD960JD10 L	WASHER
1	MS21042L3	NUT
1	MS27039-A-13	SCREW

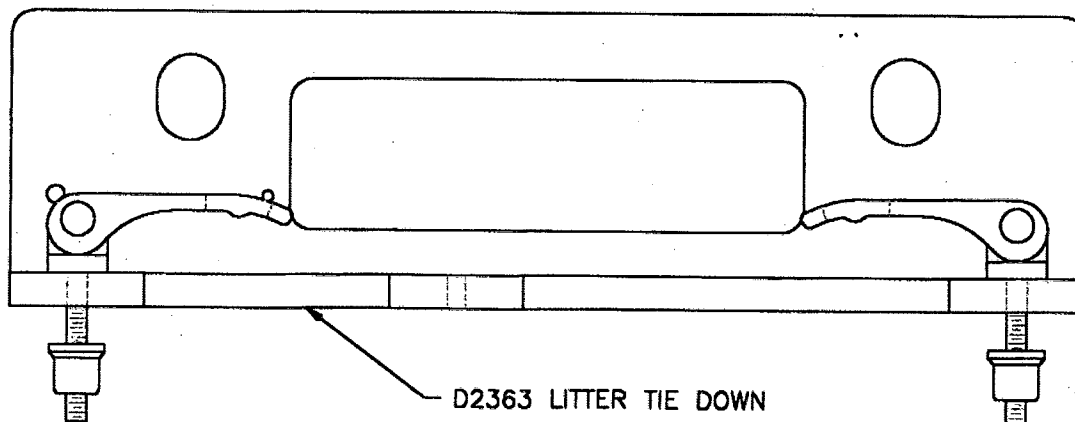
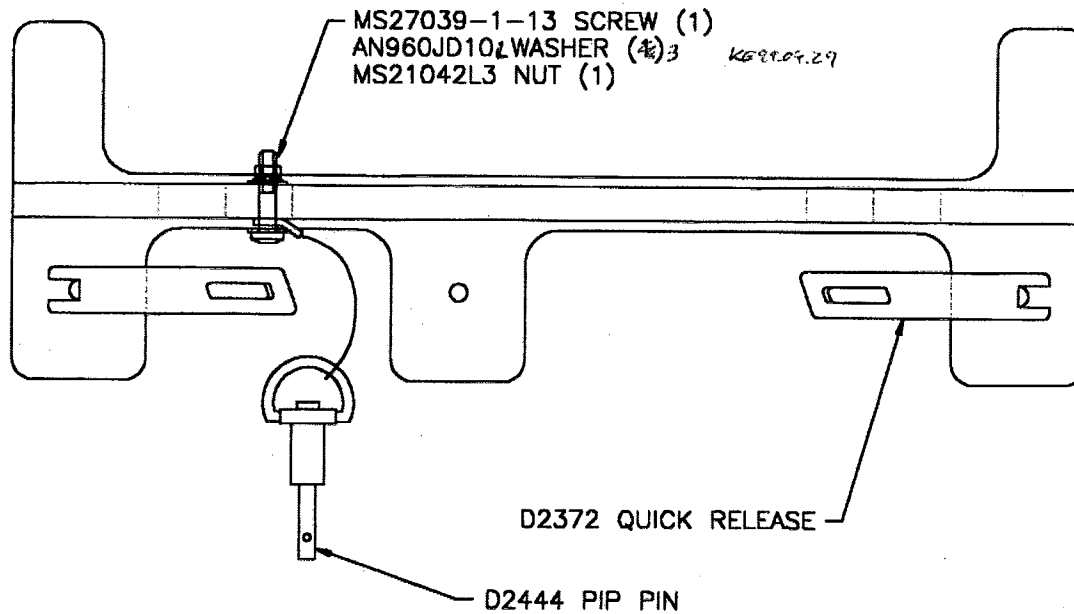
KE 99.04.29

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NO. 39221



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B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED	APPROVED	D2350	SHEET 2 OF 2
DATE		TITLE	SCALE
95:02:20		LITTER TIE DOWN ASSEMBLY	

RELEASED
960607



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Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: May 20, 2008 3:11 PM
To: 'Chris Provencal'
Cc: 'Mike Petsche (E-mail)'
Subject: RE: NCR D2363 Litter Tie Down

Chris,

I agree. These parts are acceptable.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Tuesday, May 20, 2008 11:13 AM
To: 'David Shepherd'
Cc: 'Mike Petsche'
Subject: NCR D2363 Litter Tie Down

David,

D2363 Litter Tie Down Bracket. Dim 1.70" is 1.65", 4.00" (ref) is 3.957", see attached pic. The stock material was undersized. I don't see a problem with this.

-Chris

No virus found in this incoming message.

Checked by AVG.

Version: 7.5.524 / Virus Database: 269.23.21/1456 - Release Date: 5/20/2008 6:45 AM

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Checked by AVG.

Version: 7.5.524 / Virus Database: 269.23.21/1456 - Release Date: 5/20/2008 6:45 AM